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D3371-041
Job Sheet 198791



Part No: D3371-041

Job Qty: 5 pcs

Part Name: Tail Rotor Pedal Lock



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/18/19

Description:

Type: SOLD

Note: DWG REV B IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	5 pcs	9/18/19	9/18/19	0.00	2.66	Small Fab - 1		DAS 58 SEP 2 4 2019 0.00
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
130	Small Fab - 2 - B4B	5 pcs	9/18/19	9/18/19	0.00	2.66	Small Fab - 1 - B4B		DAS 58 SEP 2 4 2019 0.00
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
140	Small Fab - 3 - B4B	5 pcs	9/18/19	9/18/19	0.00	2.66	Small Fab - 1 - B4B		DAS 58 SEP 2 4 2019 0.00
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
150	QC 5	5 pcs	9/18/19	9/18/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		

Plex 8/6/19 1:23 PM Dart.lajeunesse.marie

				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40	SEP 2 5 2019	DAS 40 9-89
				QC 5 - 61		
				QC 5 - 81		
160 Packaging 3-1 - Stock - B4B 5 pcs	9/18/19	0.00 0.00		Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
170 QC 21 - SA 5 pcs	9/18/19	0.00 0.00		QC 21 - SA - 21	SEP 2 5 2019	DAS 70 9-89
				QC 21 - SA - 70		
				QC 21 - SA - 53		
Part Op 120 - ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble Descriptions: hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051. 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest. 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut. Qty Part Number Description Batch A/R 262 Locktite						
130 - Assemble lanyard to cyclic sock as per Dwg D3384 Identify as D3384-045 MANUFACTURE D2690-24 LAND YARD AS PER DWG						
140 - 1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4						

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150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location:)
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
238-028	3/16" Dowel Pin .5" long	10 Ea (2 ea)	120-Small Fab - 1	5173618
AN526C832R6	Screw	20 Ea (4 ea)	120-Small Fab - 1	fm131379
D2728-7	Dart Logo Label	5 (1 ea)	120-Small Fab - 1	5212203
D3371-1	Pedal Lock Base	5 pcs (1 ea)	120-Small Fab - 1	5213020
D3371-3	Pedal Lock Cover	5 pcs (1 ea)	120-Small Fab - 1	5163943
D3373-7	Cam Lock	5 pcs (1 ea)	120-Small Fab - 1	5172722 + 130002
D3385-3	Hinge	5 pcs (1 ea)	120-Small Fab - 1	5197035
CBL-1240	Cable	8.3330 ft (1.6666 ea)	130-Small Fab - 2 - B4B	5187877
CBL-460	Loop Sleeve	10 Ea (2 ea)	130-Small Fab - 2 - B4B	5209716
D3384-1	Cyclic Sock	5 pcs (1 ea)	130-Small Fab - 2 - B4B	5173616
HX-81	1/4"-20 SHCS 3/8" long	5 Ea (1 ea)	140-Small Fab - 3 - B4B	5201001
NAS1149F0463P	Washer (AN980-416)	10 Ea (2 ea)	140-Small Fab - 3 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	238-028	10	32	0
	AN526C832R6	20	28	0
	D2728-7	5	0	0
	D3371-1	5	2	0
	D3371-3	5	1	0
	D3373-7	5	10	0
	D3385-3	5	9	0
	CBL-1240	8	658	0
130-Small Fab - 2 - B4B	CBL-460	10	729	0
	D3384-1	5	13	0
	HX-81	5	23	0
140-Small Fab - 3 - B4B	NAS1149F0463P	10	547	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

		Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge
☐ Bending	☐ Misaligned/off center	☐ Folio/Program
☐ Crushing	☐ BOM/Route	☐ Grain Direction
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up

☐	☐	☐	☐	☐	☐
Positioned Wrong	Outside Tolerance	Drawing	Finish	Part Lost/Missing	Misread

Other/Details: